

Monday, 2/27/2006 4:22:22 PM
 van Johnson

Process Sheet

SPLIT

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : LUG
Job Number : 26002 -2	
Estimate Number : 10008 B3	
Part Number : N/A	Part Number : D2591
Thru Date : 2/27/2006 S.O. No. : N/A	Drawing Number : D2591 REV D
Project : NC	Project Number : N/A
File : N/A	Drawing Revision : D
Part : 25863	Material : N/A
	Due Date : 3/15/2006
Quantity : SEE COMMENT BELOW	Qty: 22
Checked By : 06.02.28	Um: 40
Est. Rev. I Removed from 9 Digit 05 10 25 JLM	Each

Add to Bill of Materials

Job Number



Sequence

Machine Or Operation:

Description :

M1010B0750X02500

ASTM A21 Steel .75"x2.5"



Comment: Qty. 0.2340 f(s)/Unit Total: 9.3600 f(s)

ASTM A36 Steel bar 2.50" x 0.75" thick (M1010-B0.750X02.500)

Batch 18 M100283-22955

u 06.03.12

BAND SAW

BAND SAW



Comment: BAND SAW

Cut blanks: 2.700" long

JL 06/05/01 (22)

JF 06/03/02

18

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1- Machine as per Folio FA 039 and Dwg D2591

2-Deburr if required

SD/ 06.05.02

22

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD/ 06.05.02

22

QC8

SECOND CHECK



Comment: SECOND CHECK

BG 06.05.02

22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 26/05/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial on entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 26002

Part Number: D2591

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST51

AP 06/05/03 (22)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

(22) 06/05/04

U 06.05.04

Job Completion



1875

1875

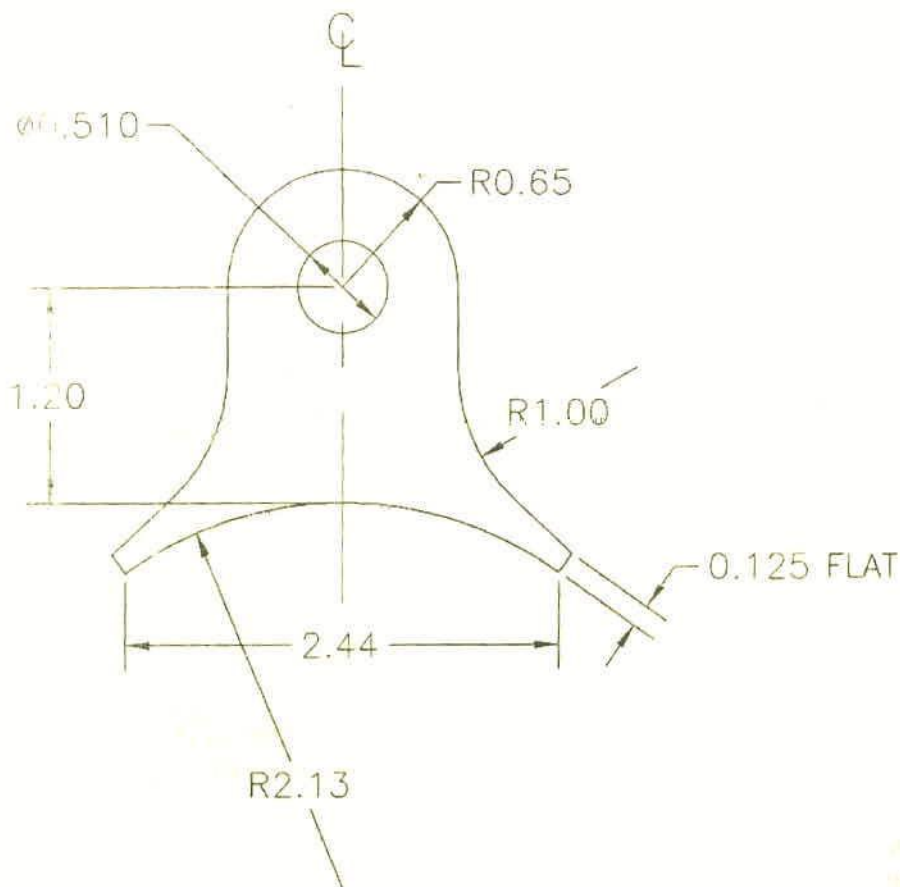
1875

1875



DESIGN <i>MEY</i>	DRAWN BY <i>MEY</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED <i>KE</i>	APPROVED <i>BS</i>	DRAWING NO. D2591	REV. D SHEET 1 OF 1
DATE 98.01.21		TITLE GHW LUG	SCALE 1:1
A	96:09:16	NEW ISSUE	
B	97:06:17	RE-DESIGN TO FLAT BOTTOM	
C	97.12.12	RE-DESIGN TO RADIUS BOTTOM	
D	98.01.21	0.125 FLAT WAS 0.067 FLAT	

RELEASED
98.01.21 DS



BREAK ALL SHARP CORNERS 0.010 TO 0.020
MATERIAL: ASTM A36 STEEL 0.50 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
PART IS SYMMETRIC ABOUT CENTER-LINE
ALL DIMENSIONS ARE IN INCHES

PREPARED
CHECKED
APPROVED
CONTROLLED COPY
SUBJECT TO APPROVAL
WITHOUT NOTICE
WORK ORDER
26002

